

Date: Friday, 18/07/2008 1:19:56 PM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT PLATE LH
<b>Job Number</b> : 40662	
<b>Estimate Number</b> : 13283	
<b>P.O. Number</b> :	<b>Part Number</b> : D36973
<b>This Issue</b> : 18/07/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3697 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 38860	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/08/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.2.18</u>	
<b>Comment</b> : Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S050	6061-T6 .050 Sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.4797 sf(s)/Unit Total : 4.7975 sf(s)  
6061T6 aluminium sheet .050" thick  
(M6061T6S050)  
Batch: 104186 AB 8-7-23

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3697  
Dwg Rev: B AB 8-7-23  
Prog Rev: B  
\*\*\*grain direction along 3.44" \*\*\*  
2- Debur if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------


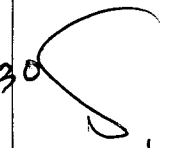




**Comment:** NC BRAKE  
Bend as per Dwg D3697

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3697-3 PAR #: PLA Fault Category: Prod/Fin Ass. mod to Draw NCR: Yes No DQA: D Date: 08/11/13  
 - (412-776-011) QA: N/C Closed: HJ Date: 08/10/24

NCR: 40662		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/7/30	# 20	During QC inspection Found 3 parts with the 0.098" hole size at 0.108" RC <del>human</del> incorrect Set off set.		Water Set operator all ready Replaced pins to <del>human</del> taking Holidays. Setup and Destroy Qty (13)	SAD 08/07/30 Sung for HB 08/07/30			 08/07/30

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE LH

Job Number: 40662

Part Number: D36973

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/22 (10)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink hole as per dwg D3697

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/10/22 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

508/10/22 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/24

Job Completion



mf 08-10-23

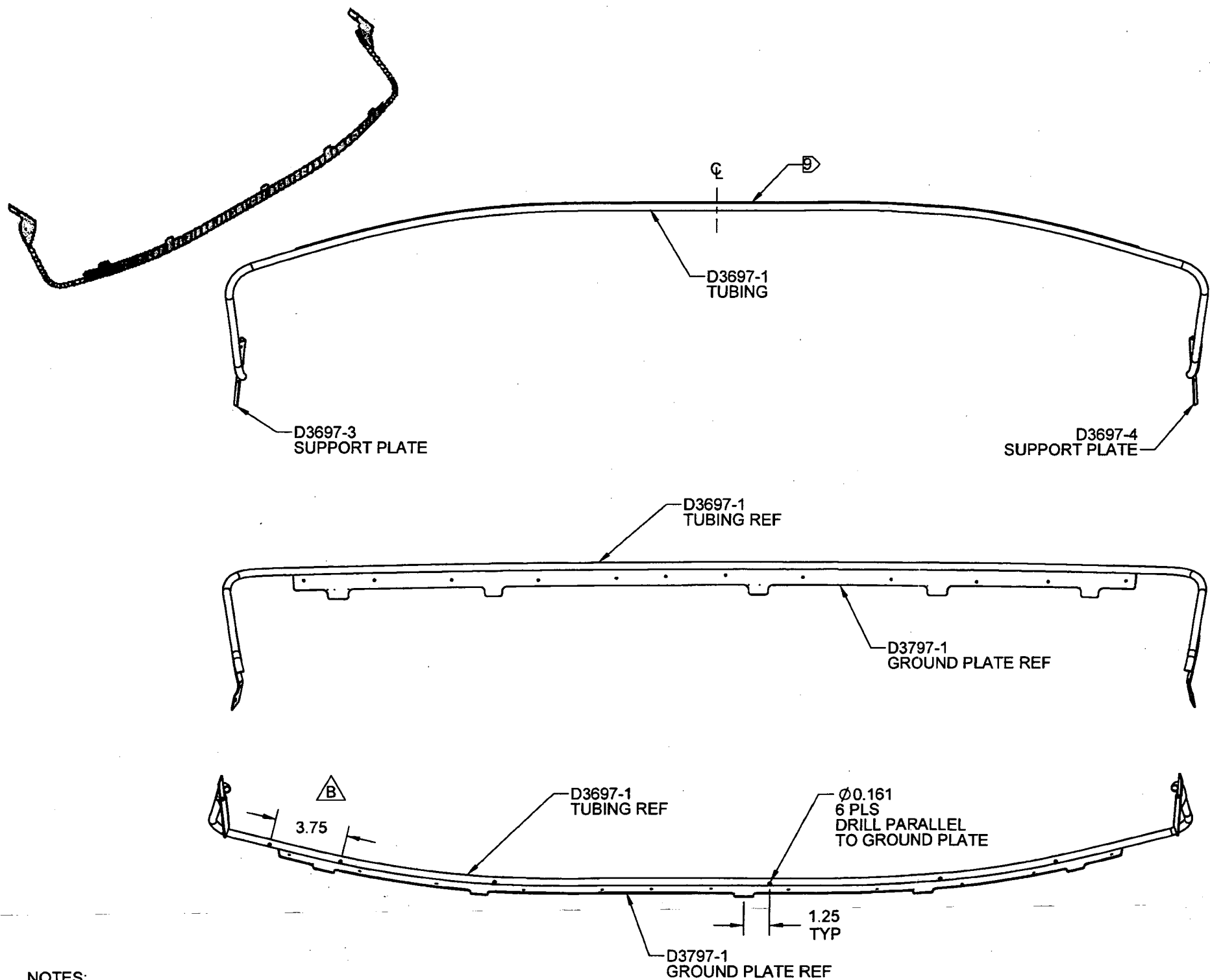
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

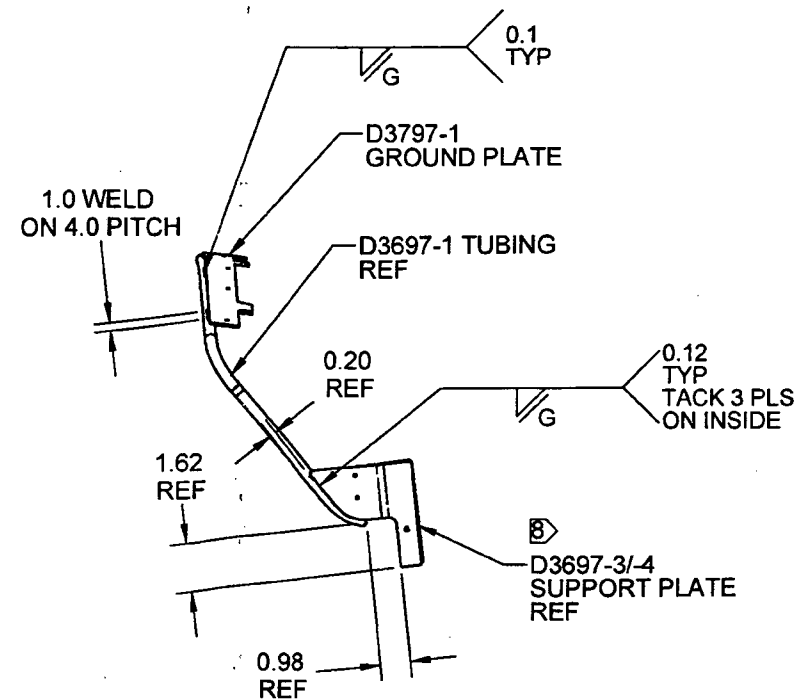
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:
- 1) WELD PER QSI 004
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.55 lbs
  - 8) LOCATE D3697-3/-4 ON D3697-1 USING DT9009 WELDING JIG
  - 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

### D3697-041 TUBE ASSEMBLY



RELEASED  
08-07-08

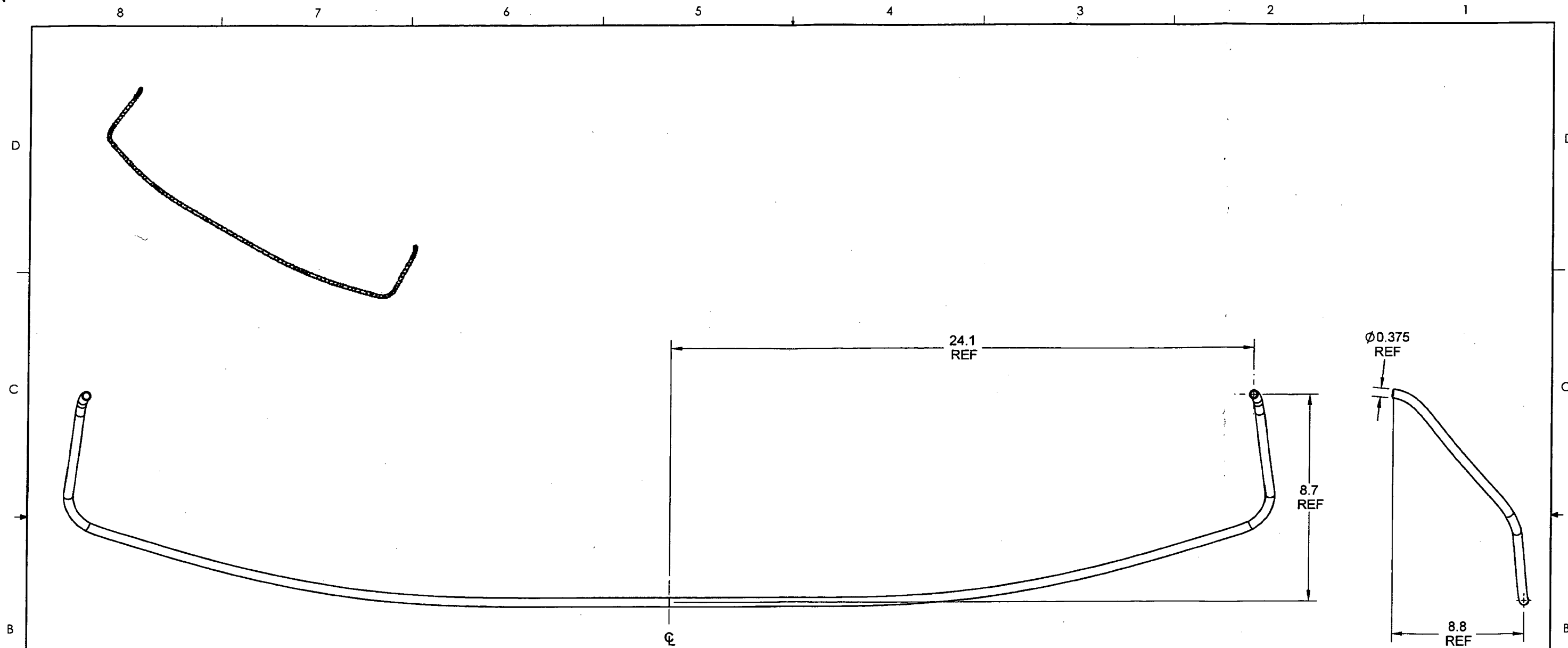
### PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42662

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A.8; ADD Ø0.161 HOLE. SHEET 1 ZONE B.7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.02		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. **D3697**  
REV. B  
SHEET 1 OF 3  
TITLE **TUBE ASSEMBLY**  
SCALE NTS  
COPYRIGHT © 2008 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**D3697-1 TUBING**

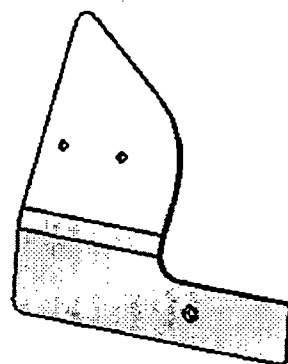
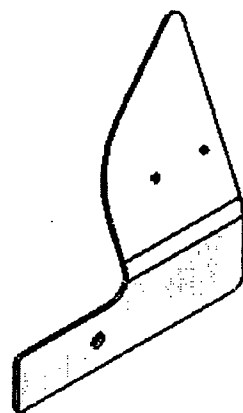
**NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WW-T-700/6) ALUMINUM TUBING  $\phi 0.375 \times 0.049$  WALL  
(REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3697</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>TUBE ASSEMBLY</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	<b>08.06.02</b>		

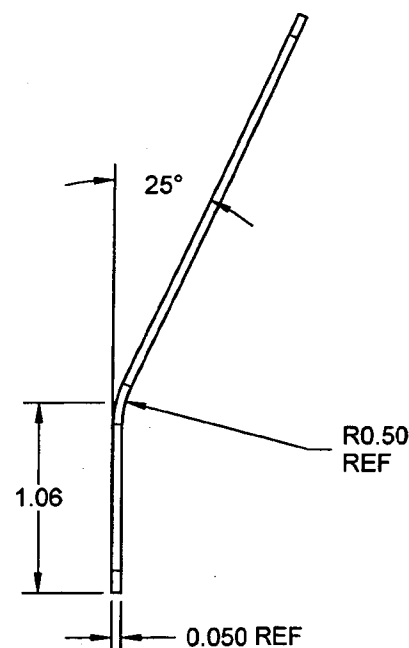
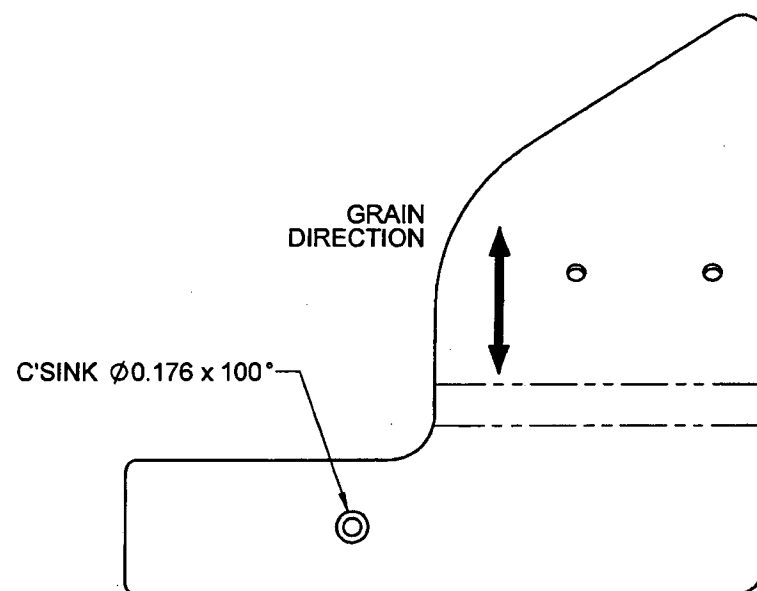
**RELEASED**  
08-07-06

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *[Signature]*

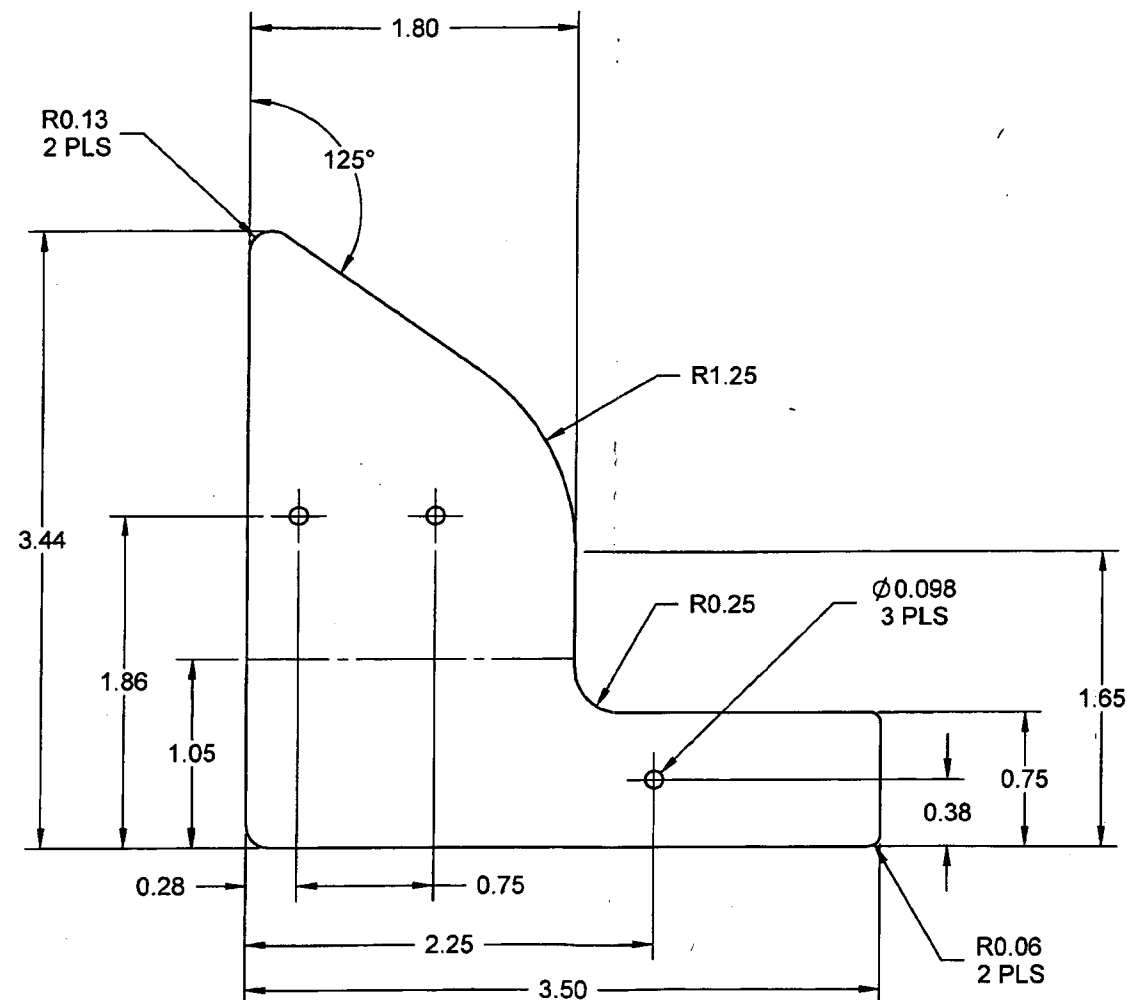


**D3697-3 SUPPORT PLATE (LH SHOWN)**

**D3697-4 SUPPORT PLATE (RH SHOWN)**



**D3697-3 SUPPORT PLATE (LH SHOWN)**  
**(D3697-4 SUPPORT PLATE OPPOSITE)**  
**(MAKE FROM D3697-3F FLAT PATTERN)**



**D3697-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

**RELEASED**  
 08-07-02

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *4000*

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3697</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TUBE ASSEMBLY</b>	NTS
DATE	<b>08.06.02</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

